December 8, 2009 11:25:07 AM Item ID: D3762-3 Accept Setup Start **Revision ID:** Stop Item Name: Tube **Start Qty: 16.00** Start Dete: 08/12/2009 **Cust Item ID:** Req'd Qty: 16.00 Required Date: 16/12/2009 **Customer:** Reference: Start Run Tooling: **Process Plan:** Date: Approvals: Stop Date: QC: SPC (Y/N): Date: Reject Operation Set Up/ Draw Plan Accept Reject Insp. Draw Sequence ID/ Number Rev. Code Qty Qty Number Stamp Description Work Center ID **Run Hours Draw Nbr Revision Nbr** D3762 Rev A 0.00 100 DOOSAN LATHE 0.00 Doosan 1- Turn as per Folio FA749 Rev: N//+ & Dwg D3762 Rev: A □2-Deburr Doosan Lathe per dwg D3762 QC2- Inspect parts off machine FAI/FAIB 0.00 110 0.00 QC Memo Quality Control QC8- Inspect parts - second check 0.00 120 0.00 Memo Quality Control

Dart Aerospace Ltd

W/O.	<u> </u>		\MC	DI ODDED OLIANO							
W/O:			VVC	ORK ORDER CHANG		-		1	Approval		
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Chief Eng / Prod Mgr	Approval QC Inspector	
				·					7 Tod Wigi		
		•							, , , , , , , , , , , , , , , , , , ,		
									155°		
									7.		
David Ma											
Part No			•				No DQA : Date :				
	Re	esolution:							Date: _		
NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE	(NCR)					
DATE	CTED	Description of NC Corrective Action Section					Verific	ation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector	
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	1										
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NOTE: Date & initial all entries

Work Order ID 54370



Page 2

December 8, 2009 11:25:07 AM

Required Datc: 16/12/2009

Item ID:

D3762-3



Setup Start

Stop

1.14



Revision ID:

Start Date:

Item Name:

Tube

08/12/2009

Start Qty: 16.00 Req'd Qty: 16.00

Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ Work Center ID

Operation Description

Identify as per dwg & Stock Location: 251

Set Up/ **Run Hours** Draw Number Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

Packaging

Memo

0.00

0.00

10-1-5

Packaging

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W 10.01.15

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W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE	E	By Date Qty			Approval Chief Eng / Prod Mgr	Approval QC Inspector
		÷								
		,:								
									•	
Part No	•	PAR #:	Fault Cat	egory:	NCR:	Yes I	No DQA	\:	Date:	
	, R	esolution:	Dispositi	on:	QA: N	/C Clo	sed: Date:			
NCR:	, -		WORK OR	DER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verificati			n Approval	Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section		Approval Chief Eng	QC Inspector
	,									
						_				
					*					
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NOTE: Date & initial all entries

Picklist Print

December 8, 2009 11:25:13 AM

Work Order ID: 54370

Parent Item:

D3762-3

Parent Item Name: Tube



Start Date: 08/12/2009

Required Date: 16/12/2009

Page 1

Required Oty: 16.00

Comments:							Start Qty: 16.00			Required Qty: 16.00		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			110	f	28.1121	1.8189			
ooo To Round But 1.250				Wareho Loca	use ation	Loc	<u>Qty</u>	Loc Code	!			
				Main Wa	arehouse							
				MA	Т	28.	1121		_		-	?
					108876 109733		9.6 7.04		· · · · · · · · · · · · · · · · · · ·			•

9.1021

2.37

113457

111321 18295

- JL10/01/05

Dart Aerospace Ltd

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		WC	RK ORDER CHANG	ES					
STEP	PRO	OCEDURE CHA	NGE	By Date Qty				Approval Chief Eng / Prod Mgr Approval QC Inspector	
			· · · · · · · · · · · · · · · · · · ·						
:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:		
				QA: N/C Closed:			Date:		
		WORK ORDI	ER NON-CONFORMA	ANCE (NCF	R)				
STEP	Description of NC	Corrective Action		Section B Ve				Approval	
	Section A	Chief Eng	Chief Eng	Date	Secti	tion C Chi	Chief Eng	QC Inspector	
			, , , , , , , , , , , , , , , , , , , ,						
				-					
		:PAR #:	STEP PROCEDURE CHARACTERS PROCEDURE CHARACTERS PAR #: Fault Cates Resolution: Disposition WORK ORDI STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Corrective Action Sect Initial Action Description	PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C Cl WORK ORDER NON-CONFORMANCE (NCR WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC	STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQ. Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	54370
Description: Tube	Part Number:	D3762-3
Inspection Dwg: D3762 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	le _	Proto	type			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Metho Inspe		Com	nments
Ø0.188	+0.005/-0.001	-188						
0.05 x 45°	+/-0.030 x +/-0.5°	OSXYS°						
1.30	+/-0.030	1.30						
0.65	+/-0.030	.651						
Ø0.257	+0.006/-0.001	.258						
Ø1.010	+0.010/-0.000	1.015						
Ø1.20	+/-0.030	1.201						
63°	+/-0.5°	630						
27°	+/-0.5°	270	1					
27°	+/-0.5°	270	V					<u></u> .
63°	+/-0.5°	630	/					
Measured by:	<u></u>	Audited by:	H.A		Proto	type Ar	proval:	N/A
Date:	~ 110 lei		10 0 1104			-2 11	Date:	N/A
	09/12/3/	Date.	170HOC					
Rev Date	Change					Revise KJ/DD	ed by	Approved



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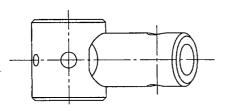
UNCONT:

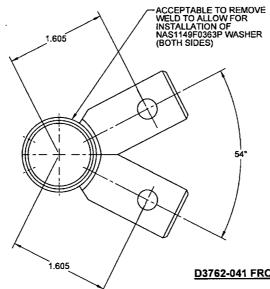
SUBJECT

WITH

WOR. NO. 54378 OF 04-12-8

D





ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

D3762-041 FRONT LEG FITTING ASSY

Α	NEW IS	HS	08.06.04					
REV.			BY DATE					
DESIG	4	HS	DART AEROSPACE LTD					
DRAW	٧.	HS	HAWKESBURY, ONTARIO,					
CHECKED MFG. APPR.		J¥J	DRAWING NO.		REV. A			
			D3762		SHEET 1 OF 3			
APPROVED ///		No.	TITLE		SCALE			
DE APPR.			FRONT LEG FITTING		NTS			
DATE	08.0	16 04	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS					

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.05 lbs
8) WELD: PER DART QSI 004

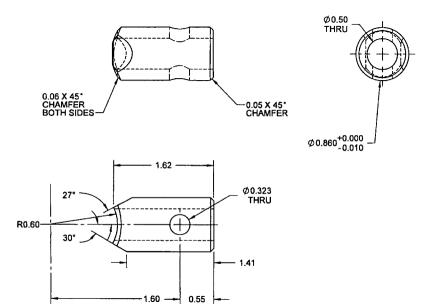
3

3

8

7

6



D3762-1 FITTING



NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R) (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-20(2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA ORAWING NO. CHECKED POF REV. A D3762 MFG. APPR. SHEET 2 OF 3 APPROVED TITLE SCALE FRONT LEG FITTING DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD
IT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION OF PRIVATE AND PURPOSE ON COPIED ON COMMUNICATED TO ANY OTHER PERSON. DATE 08.06.04

3

- Ø0.188 THRU (2 PL) Ø1.010^{+0.010} Ø1.20 -0.05 X 45° CHAMFER Ø0.257 0.65 THRU



D

D3762-3 TUBE

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)

(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-/
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3762 MFG. APPR. SHEET 3 OF 3 TITLE APPROVED SCALE FRONT LEG FITTING DE APPR. NTS

DATE 08.06.04

8

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